

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006227**Date Inspected:** 09-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1030**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Chung Fu Kuan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

On this date, 4/9/09, Caltrans OSM Quality Assurance (QA) Inspector Mike Brcic was present during the times noted above for observations relative to the work being performed on castings, in either the Fabrication shop #4 or Foundry Shop at Japan Steel Works.

Reviewed Mr Chung Fu Kuan's daily records regarding weld process and controls, all records appear accurate and parameters meet requirements of Weld Quality Control Plan.

W2E3 - Cast section being cleaned at areas requiring "butter" for temporary lifting lugs.

W2W2 - Magnetic Particle testing (MT) was being finished in trough areas, wet/continuous/AC/yoke method.

Level II technician was Mr Kohama.

W2W3 - Repairs are having their excess reinforcement removed by way of grinding to clean up surface left by carbon arc the previous day.

T1-1 - Observed Quality Control (QC) Ultrasonic Technician Mr. Sato and Mr. Kobayashi performing UT of CJP welds.

T1-2 - Tower saddle was being rotated to prepare for more welding. No welding performed on this section during QAI 's review of shop.

T1-3 - Weld procedure SJ3012-1-1, (buttering of cast material) was used by welder # 07-4510, 9Y-10U radius of rib to stem (1st layer), all governing contract documents and special provisions appeared to be met at this time.

E2E1 - Riggers were preparing to move casting to a location for mechanical shaping by way of grinding.

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E2W1 - Casting sitting idle.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

Summary of Conversations:

No significant conversations to report on this day.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Brcic,Michael	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer
